

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017181**Date Inspected:** 23-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Geng Wei & Mr. Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Bike Path and Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 044771 perform Submerged Arc Welding (SAW) Welding on OBG Segment 13AE, weld joint identified as SEG3007-006. ZPMC QC is identified as Mr. Zhong Guo Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 066439 perform Flux Core Arc Welding (FCAW) welding on vertical plate of OBG Segment 13AE, weld joint identified as VP3007-001-077. ZPMC QC is identified as Mr. Zhong Guo Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 067079 perform FCAW welding on vertical plate of OBG Segment 13CE, weld joint identified as VP3007-001-063. ZPMC QC is identified as Mr. Zhong Guo Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 067876 perform FCAW welding on

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 4 )

---

vertical plate of OBG Segment 13AE, weld joint identified as VP3007-001-037. ZPMC QC is identified as Mr. Zhong Guo Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 048047 perform Shielded Metal Arc Welding (SMAW) welding on OBG Segment 13AE Bottom plate temporary attachment areas, the bottom plates are identified as BP3030, BP3031, BP3032 and BP3033. ZPMC QC is identified as Mr. Guo Xing Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-1G (1F)-Repair, which is used as per Critical Welding Repair Report (CWR) B-CWR-1833.

This QA inspector observed ABF personnel performing Magnetic particle Testing (MT) on OBG Segment 13AE Bottom plate temporary attachment areas. The bottom plates are identified as BP3030, BP3031, BP3032 and BP3033.

This QA inspector observed ZPMC personnel performing Ultrasonic Testing (UT) on OBG Segment 13AE Bottom plate (60mm thk) to Bottom plate (100mm thk) splice joint. The weld joint is identified as SEG3007AC-002. ZPMC QC is identified as Mr. Geng Wei. See the attached picture.

### Bay 16

This QA inspector observed ZPMC qualified welding personnel identified as 066751 perform FCAW welding on steel barrier of OBG Component, weld joint identified as W5-SB1E-001-013, 014, 015 and 016. ZPMC QC is identified as Mr. Guo Pan. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 066751 perform FCAW welding on steel barrier of OBG Component, weld joint identified as W5-SB1E-001-095 and 099. ZPMC QC is identified as Mr. Guo Pan. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2332-Tc-P4-F.

This QA inspector observed ZPMC qualified welding personnel identified as 068494 perform FCAW welding on steel barrier of OBG Component, weld joint identified as W5-SB1-023-001 to 012. ZPMC QC is identified as Mr. Guo Pan. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2133.

This QA inspector observed ZPMC qualified welding personnel identified as 067765 perform FCAW welding on steel barrier of OBG Component, weld joint identified as W5-SB1-017-019. ZPMC QC is identified as Mr. Guo Pan. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2331-Tc-P4-F.

### Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 062761 perform Flux Core Arc Welding (FCAW) welding on Suspender bracket, weld joint identified as SB017-90-001 and 005. ABF QC is

# WELDING INSPECTION REPORT

( Continued Page 3 of 4 )

identified as Mr. Peng Wen Jun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2231-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062749 perform FCAW welding on Suspender bracket, weld joint identified as SB017-86-001 and 005. ABF QC is identified as Mr. Peng Wen Jun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2231-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062752 perform FCAW welding on Suspender bracket, weld joint identified as SB017-88-001 and 005. ABF QC is identified as Mr. Peng Wen Jun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2231-Tc-U4b-F.

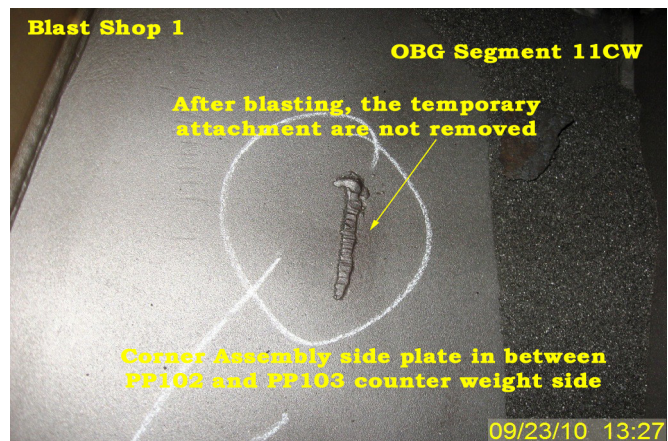
This QA inspector observed ZPMC qualified welding personnel identified as 062783 perform FCAW welding on Suspender bracket, weld joint identified as SB020-88-004. ABF QC is identified as Mr. Peng Wen Jun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2232-Tc-U4b-F.

## Visual Inspection after Blast

### Segment 11CW

This QA Inspector performed a preliminary random visual inspection on OBG Segment 11CW, after the grit blast of the interior components of the deck panel, floor beams and corner assemblies of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection. See the attached pictures.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



## Summary of Conversations:

---

## WELDING INSPECTION REPORT

( Continued Page 4 of 4 )

---

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Kumar,Vibin	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

---